

**Work Order ID 52603**

October 3, 2009 8:42:13 AM



ASAP

Page 1

Item ID: PB67-43001-205

Accept



Setup Start



Revision ID: C

Stop



Item Name: Outer Tube

Start Date: 10/05/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/06/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 09-10-03 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- cut to length as per dwg  
2-cut a angle on one end of tube as per dwg  
3- deburr

*09.10.04*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes and mill slot as per dwg PB67-43001 USE DT8792  
2- deburr

*09.10.04 (2)*

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*2) 502/1062**(2)**f*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: *m108436* 0.00

Large Fab

Memo

0.00

1-Weld end cap as per dwg PB67-43001  
2-grind end cap flush

*pl 09 10 07*

140



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

Memo

0.00

*⇒ 8/9/10/07*

*(x2) f*

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*⇒ 5/9/10/07*

*(x2) f*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Work Order ID 52603

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Page 3

Item ID: PB67-43001-205

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Revision ID: C

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Item Name: Outer Tube

Start Date: 10/05/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/06/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: *Stores*

0.00



Packaging

Memo

0.00

Packaging

*PC 09 10 07*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/10/07 JF*  
*MF 09-10-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

October 3, 2009 8:42:13 AM

Page 1

Work Order ID: 52603

Parent Item: PB67-43001-205RevB1

Parent Item Name: Outer Tube


Start Date: 10/05/2009

Required Date: 10/06/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			100	f	83.4000	7.6105			
												
6061T6 RDTUBE 1.750 X 0.65W												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

83.4

108551

2.24

109397

4.47

110885

16.69

111432

60

130

Each

26.0000

2.0000

PB67-43001-199RevB1

Manufactured No



Outer Tube End Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

26

41571

3

44991

23

*df 09.10.06*

3.781  
3.781

*09.10.07*

*209.10.07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 52603
<b>Description:</b> OUTER TUBE	<b>Part Number:</b> B67-43001-205
<b>Inspection Dwg:</b> B67-43001-Rev: C	<b>Page 1 of 1</b>

205

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.745 2pl	+/- .010	.745	✓			
.745 2pl	+/- .010	.745	✓			
.50	+/- .030	.50	✓			
1.50	+/- .030	1.50	✓			
33.45	+/- .030	33.450	✓			
34.45	+/- .030	34.450	✓			
35.35	+/- .030	35.35	✓			
8.25	+/- .030	8.25	✓			
45.38	+/- .030	45.38	✓			
R.38	+/- .030	R.38	✓			
.75	+/- .030	.75	✓			
27°	+/- 1/2°	27°	✓			
1.75	+/- .030	1.75	✓			
.065	+/- .010	.065	✓			
36.88	+/- .030	36.88	✓			
.250	+ .006 - .001	.250	✓			
.125	+ .004 - .001	.125	✓			

<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09.10.7	<b>Date:</b> 08/10/07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**B67-43001-205 OUTER TUBE**

RELEASED  
2009-09-24

NOTES:

- NOTES:
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING  
PER VWW-T-700/6 OR AMS4080 OR AMS 4082 OR  
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF. DART SPEC. M6061T6T1.750W.065
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.46 lbs

C	REDRAWN PREMIER AVIATION DRAWING LAW DART QSI 018 AND QSI 043 FOR PREVIOUS REVISIONS. REFER TO SHEET 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>B67-43001-205</b>  TITLE <b>OUTER TUBE</b>	REV. 1 OF 1	
DRAWN			SHEET 1 OF 1	
CHECKED			SCALE	
MFG. APPR.			NT	
APPROVED				
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY.		
DATE	09.02.27			

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